

Date: Thursday, 02/04/2009 2:27:29 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHOULDER HARNESS KIT
Job Number : 46870	
Estimate Number : 13048	
P.O. Number :	Part Number : D350764011
This Issue : 02/04/2009 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 46595	Material :
Written By :	Due Date : 17/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JD 09-01-03</u>	
Comment : EST REV:A New issue 07-10-11 DD verified by EC Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-764-011

CHC002
CHC001

5 9/4/4

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

3.0	D2854	3/4" Velcro Strip
-----	-------	-------------------

**Comment:** Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8" each) as per dwg D2854

Batch: B39405

SP

4.0	D2854	3/4" Velcro Strip
-----	-------	-------------------

**Comment:** Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8" each) as per dwg D2854

Batch: B39405

SP

5.0	D3578041	Doubler
-----	----------	---------

**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

DOUBLER

batch 46653

9/4/4

K

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D3636041

Shoulder Harness



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
SHOULDER HARNESS
batch B4698

SP

7.0

D3637041

Bracket Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BRACKET ASSEMBLY
batch B43353

SP

8.0

D36373

Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BRACKET
batch B43184

SP

9.0

D36381

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BUSHING
batch B45846

SP

10.0

D36391

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DOUBLER
batch B35128

SP

11.0

D36392

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DOUBLER
batch B42299

SP

12.0

D36393

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DOUBLER
batch B35382

9/4/7

SP

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D36394

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DOUBLER

batch 135383

SP

14.0

D36401

Belt Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch 1343354

SP

15.0

D36403

Belt Guide



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BELT GIUDE

batch 1513356

SP

16.0

D36411

Cover



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

COVER

batch 1345829

SP

17.0

D36413

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch 1343232

SP

18.0

D36414

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COVER

batch 1344671

SP

19.0

D36421

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

batch 1343234

9/4/1

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D36431

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch B34549

50

21.0

D36432

Stiffener



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STIFFENER

batch B34548

50

22.0

D36441

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SHIM

batch B35392

50

23.0

D36571

Guide Tool



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GUIDE TOOL

batch B34550

50

24.0

ALS41032130

Insert



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Insert

batch M110511

50

25.0

AN33A

Bolt



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

batch M110865

50

26.0

AN36A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch M109752

9/6/7

(K)

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M107178

SP

28.0

AN960JD10

Washer



Comment: Qty.: 48.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

batch

M110523

SP

29.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M110363

SP

30.0

AN960JD616

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M110704

SP

31.0

AN9706

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch

M109798

SP

32.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Cherry Rivet

batch

M107707

M110628

SP

33.0

CR321242

Cherry Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cherry Rivet

batch

M110806

9/4/7

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:30 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

34.0	CR3212504	Rivet
------	-----------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rivet

batch

M106321

35.0	CR3212507	Rivet
------	-----------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rivet

batch

M105978

36.0	MS20426AD33	Rivet
------	-------------	-------



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

batch

7681

9/4/4

37.0	MS20426AD44	Rivet
------	-------------	-------



Comment: Qty.: 106.0000 Each(s)/Unit Total: 106.0000 Each(s)

Rivet

batch

M15541

38.0	MS20426AD46	Rivet
------	-------------	-------



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Rivet

batch

M105144

39.0	MS20470AD46	Rivet, Universal Head
------	-------------	-----------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Rivet, Universal Head

batch

M109371

40.0	MS21059L3	Nut Plate
------	-----------	-----------



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut Plate

batch

M106072

M107394

9/4/6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:30 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHOULDER HARNESS KIT

Job Number: 46870

Part Number: D350764011

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

MS21072L3

Nutplate



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nutplate

batch M110002

3P

42.0

MS35206267

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch M109389

9/4/09

SE

43.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Sort 109

44.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-764-011

Location: 52

PPP Rev: B

9/4/09

K

SE

45.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 09/04/09

Job Completion



u 9/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:27:29 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46870
 Estimate Number : 13048
 P.O. Number :
 This Issue : 02/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : PURCHASED PARTS
 Previous Run : 46595
 Drawing Name : SHOULDER HARNESS KIT
 Part Number : D350764011
 Drawing Number : N/A
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 17/04/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUD 09-01-03
 Comment : EST REV:A New issue 07-10-11 DD verified by EC
 Est Rev:B ECN 1050 rev.B as per dwg 08-01-10 DD

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



JUD 09-04-07



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-764-011

CHG002 / 809/04/07

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D2854

3/4" Velcro Strip



Comment: Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-1-080 (8" each) as per dwg D2854

Batch: 239405

SP

4.0

D2854

3/4" Velcro Strip



Comment: Qty.: 2.6660 f(s)/Unit Total : 2.6660 f(s)

3/4" Velcro

Cut qty 4 D2854-3-080 (8" each) as per dwg D2854

Batch: 239405

SP

5.0

D3578041

Doubler



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

DOUBLER

batch: